

Date: Thursday, 6/21/2007 2:29:14 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	205 SKIDTUBE "I" BEAM
Job Number	33058		
Estimate Number	10346		
P.O. Number	N/A	Part Number	D2596
This Issue	6/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D2596 REV C
First Issue	N/A	Project Number	N/A
Previous Run	32652	Drawing Revision	C
Written By		Material	N/A
Checked & Approved By	<u>DP 07-06-27</u>	Due Date	7/10/2007
Comment	Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D25003100	Ext'n - 'I' Beam Web 4"  
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion <u>B36223</u>		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1  
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" <u>DP 7-6-27</u> 2- Use Jig DT8093 to drill pilot holes #30 <u>DP 7-6-27</u> 3- Open to 0.630" diameter as per Dwg D2596 <u>DP/JD 7-6-27</u> 4- Deburr		
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1  
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 <u>DP/AB 07-06-27</u>		
4.0	QC5	INSPECT WORK TO CURRENT STEP  
Comment: INSPECT WORK TO CURRENT STEP <u>BE 07-06-27</u>		
5.0	PACKAGING 1	PACKAGING RESOURCE #1  
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>L16</u> <u>DP 07-06-27</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/16/29  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 205 SKIDTUBE "I" BEAM

Job Number: 33058

Part Number: D2596

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



26

Comment: FINAL INSPECTION/W/O RELEASE

DAR001/29

Job Completion



u 87-0628

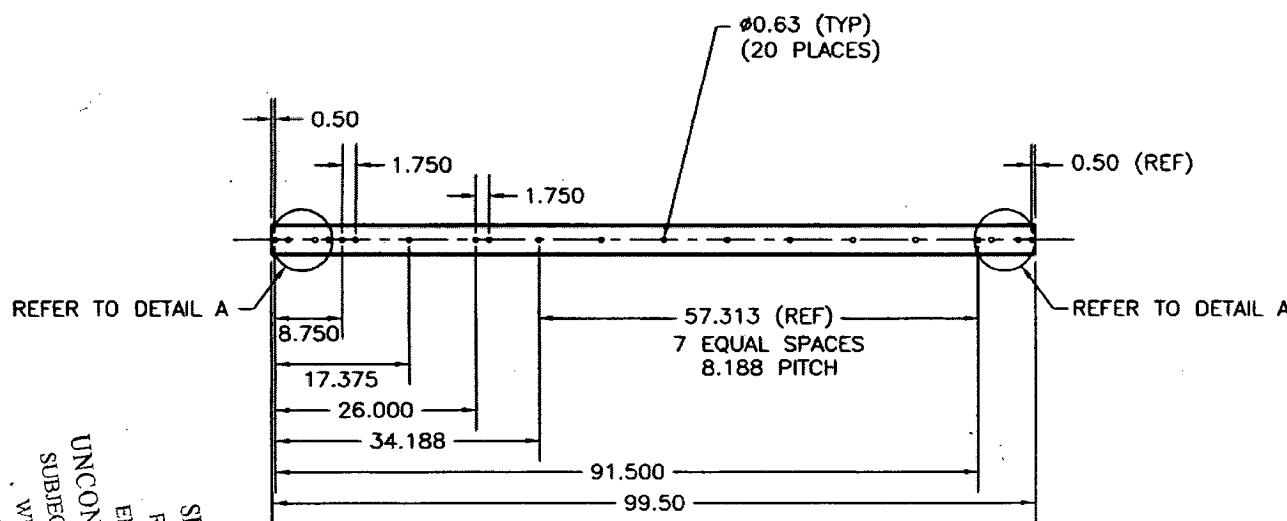
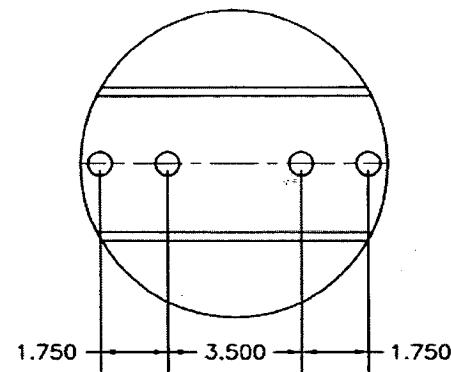
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A  
SCALE 5:24



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 330528

MANUFACTURED FROM D2500-3 EXTRUSION  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**  
18.09.17 DS

**DART**



DESIGN <i>W.H.</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>W.H.</i>	APPROVED <i>CP</i>	DRAWING NO. D2596	SHEET 1 OF 1
DATE 98.09.14	TITLE 205 WEB	SCALE 1:24	
A 98.09.14	96.09.16	NEW ISSUE	
B 98.09.14	97.07.23	Ø0.63 HOLE WAS Ø0.56	
C 98.09.14		INCORPORATED DEO 9097	